

Date: Tuesday, 5/23/2006 8:13:01 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---|--|------------------|--------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : CROSSBOLT SPACER | |
| Job Number | : 27167 | | Part Number | : D2579 | |
| Estimate Number | : 10993 | | Drawing Number | : D2579 REV D | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 5/23/2006 S.O. No. : N/A | | Drawing Revision | : D | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 6/15/2006 | |
| Previous Run | : 25977 | | Qty: | 505 | |
| Written By | : | | Um: | Each | |
| Checked & Approved By | : | | | | |
| Comment | : Est E 08.06.17 Now turned on Cobra NG | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--|
| 1.0 | M6061T6T0500W058 | 6061-T6 Tube .500 x.058W | |
| | | Comment: Qty.: 0.3762 f(s)/Unit Total : 188.1075 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch _____ | M100423 16 M101118 En / MS out of date SOS |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL | |
| | | Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245 | En / MS out of date SOS |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | En / MS out of date SOS |
| 4.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | SA 06.06.08 SOS |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| | | Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ | SA 06.06.09 505 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | 16 | | |
| | | | | | | | |

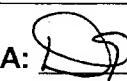
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 5/23/2006 8:13:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 27167

Part Number: D2579

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

505

Inspection Level 21

100606/09

Job Completion



in 06-06-09

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector | | |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 27167 |
| Description: Cross Bolt Spacer | Part Number: | D2579 |
| Inspection Dwg: D2579 Rev: D | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

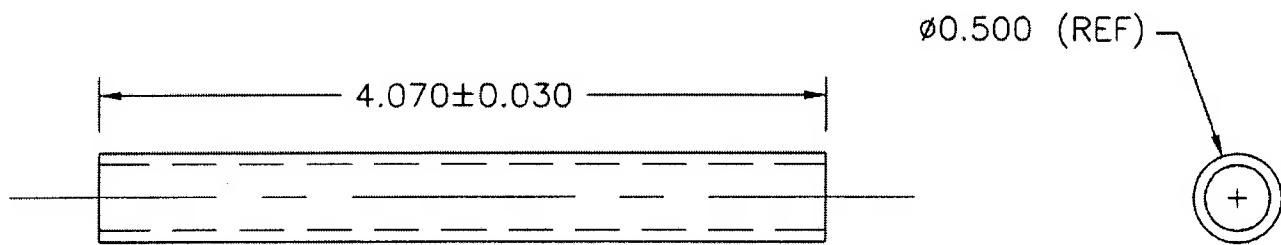
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | EP | Audited by: | JL | Prototype Approval: | N/A |
| Date: | 06/06/07 | Date: | 06/06/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 03.11.27 | New Issue | KJ/RF | PT |

DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>DR</i> | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>ME</i> | APPROVED <i>ME</i> | DRAWING NO. D2579 | REV. D SHEET 1 OF 1 |
| DATE 99.05.19 | | TITLE CROSS BOLT SPACER | SCALE 1:1 |

| | | |
|---|----------|------------------------------------|
| A | 96.09.16 | NEW ISSUE |
| B | 96.12.05 | 0.065 WALL WAS 0.035 WALL |
| C | 97.02.21 | 0.058 WALL WAS 0.065 WALL |
| D | 99.05.19 | 4.070 LENGTH WAS 4.100 (TSR A1095) |

RELEASED
 99.05.20 DS


MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
 0.500 DIA x 0.058 WALL
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27167

SHOP COPY
 RETURN TO
 ENGINEERING